

**Work Order ID 63568**

Thursday, November 04, 2010 1:12:14 PM



Page 1

Item ID: D3536-15

Revision ID:

Item Name: Gasket

Start Date: 11/4/2010 Start Qty: 20.00

Required Date: 11/12/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

Memo

0.00

B10-11-16

fj

I-Cut as per Dwg D3536  Dwg Rev: A  Prog Rev: A  2-  
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

B10-11-16

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

S10/11/16

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 63568**

Thursday, November 04, 2010 1:12:14 PM



Page 2

Item ID: D3536-15

Revision ID:

Item Name: Gasket

Start Date: 11/4/2010 Start Qty: 20.00

Accept



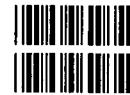
Setup Start



Stop



Required Date: 11/12/2010 Req'd Qty: 20.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: 150Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

10/11/17

(24)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CD 10/11/17

10-11-17  
(24)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Thursday, November 04, 2010 1:12:18 PM

Page 1

Work Order ID: 63568



Parent Item: D3536-15



Parent Item Name: Gasket

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	495.6220	0.9848	21.88444	 21 B10-11-16		

NEOPRENE SHEET 0.063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	495.622	
115500	95.622	
115916	400	115916

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63568
Description: Gasket	Part Number:	D3536-15
Inspection Dwg: D3536 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	X		T	PB41
35.65	+/-0.030	35.65	X		T	
33.65	+/-0.030	33.65	X		T	
30.15	+/-0.030	30.15	X		T	
24.90	+/-0.030	24.90	X		T	
19.65	+/-0.030	19.65	X		T	
14.40	+/-0.030	14.40	X		T	
9.15	+/-0.030	9.15	X		T	
5.65	+/-0.030	5.65	X		T	
3.90	+/-0.030	3.90	X		V	PB02
8.00	+/-0.030	8.00	X		T	
16.00	+/-0.030	16.00	X		T	
24.00	+/-0.030	24.00	X		T	
0.30	+/-0.030	.310	X		V	
0.30	+/-0.030	.307	X		V	
1.89	+/-0.030	1.884	X		V	
00.19	+0.005/-0.001	.193	X		V	

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-11-16	Date:	10/11/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	SJM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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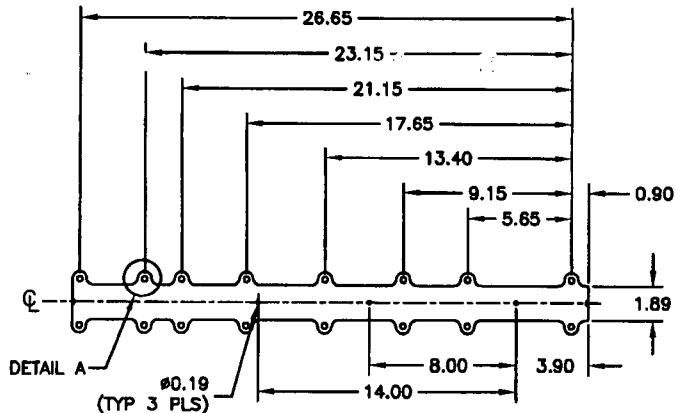
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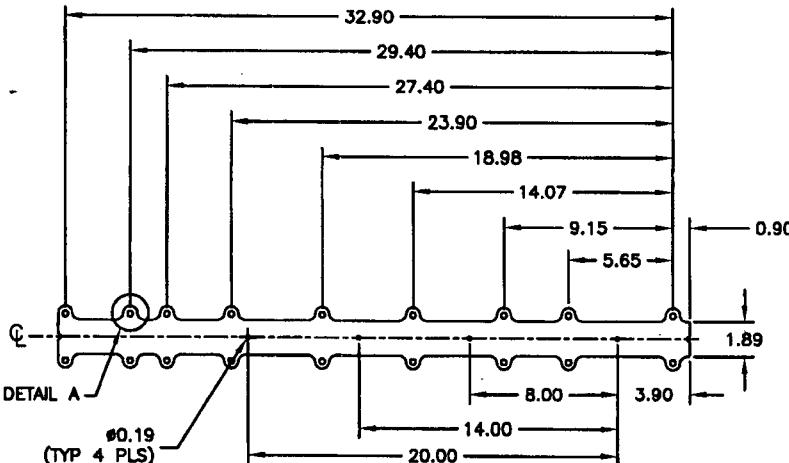
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. D3536	PORT HADLOCK, WA	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 1 OF 6	SCALE 1:10

09.02.12 -  
DRAFT ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 635 G8  
28/10/11/04



**D3536-11 GASKET**



**D3536-13 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

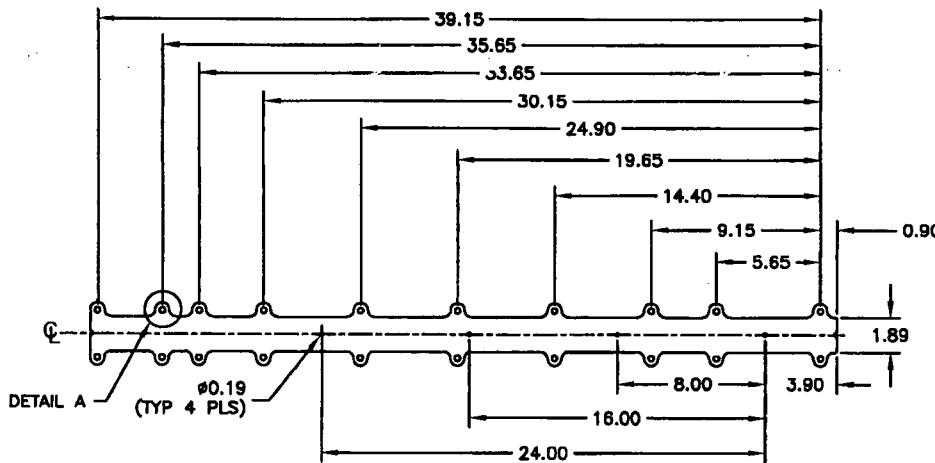
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

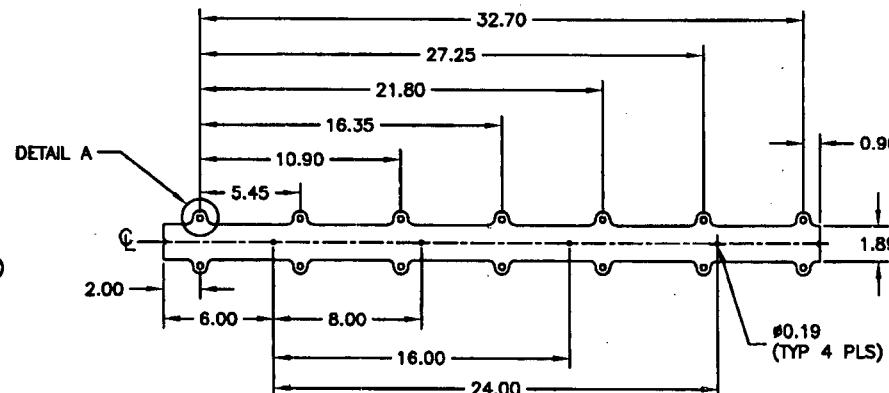
NOTE: Date & initial all entries

**DART**

RELEASED  
07.02.12



W1043568  
**D3536-15 GASKET**



**D3536-21 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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DATE 06.10.25	DRAWING NO. D3536	REV. A
SCALE 1:10	TITLE GASKET	SHEET 2 OF 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

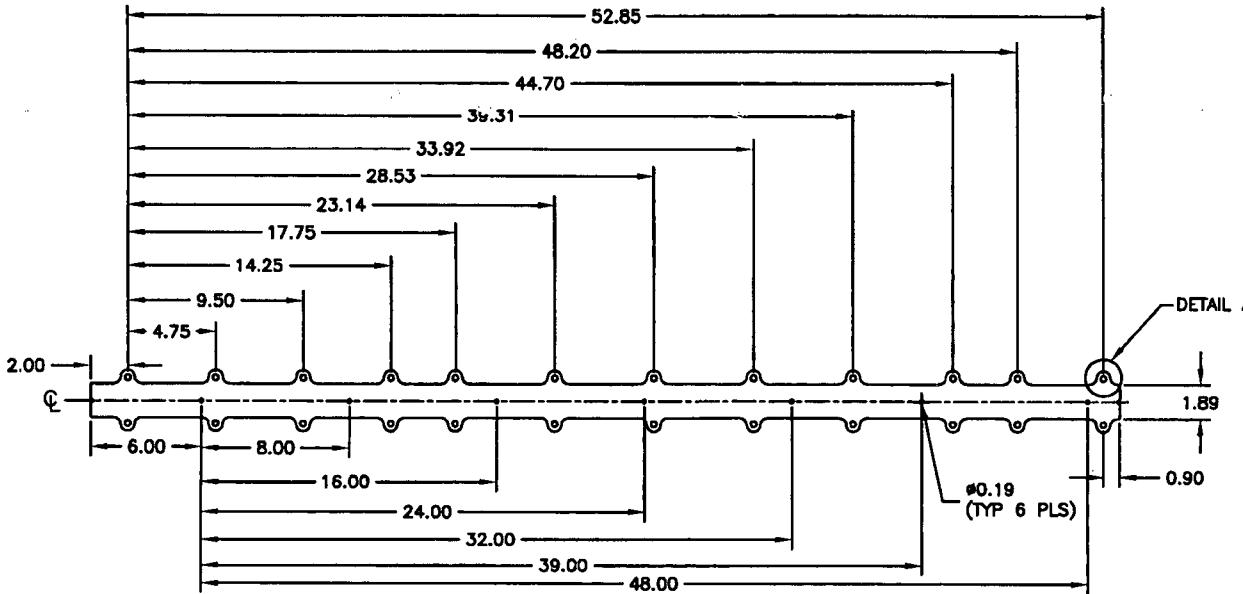
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

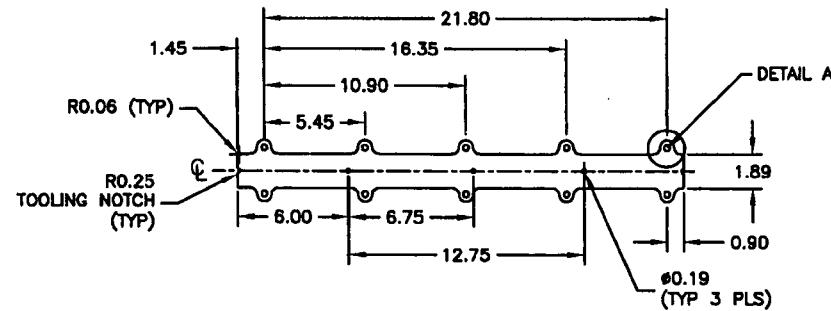
**DART**

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DATE 06.10.25	DRAWING NO. D3536	SHEET 3 OF 6
	TITLE GASKET	SCALE 1:10

07.02.02  
M

**D3536-23 GASKET**

u/b 43548

**D3536-25 GASKET**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

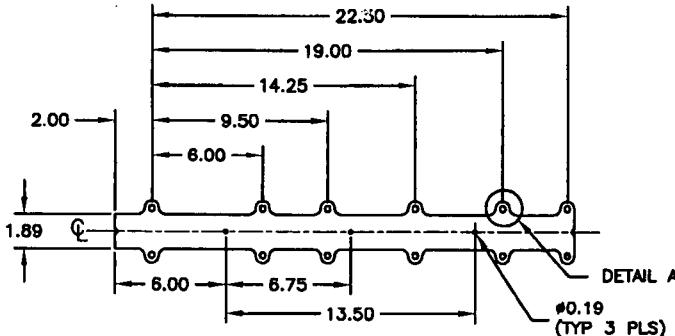
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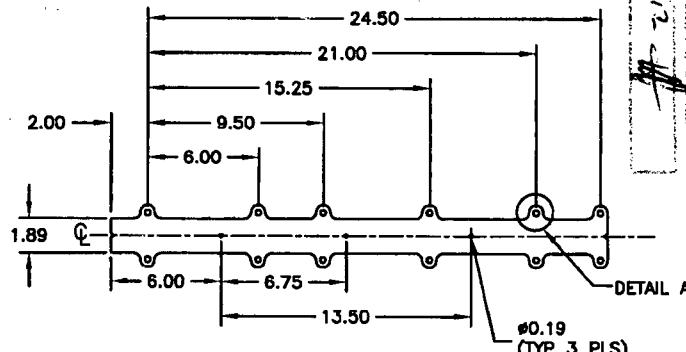
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D3536-31 GASKET

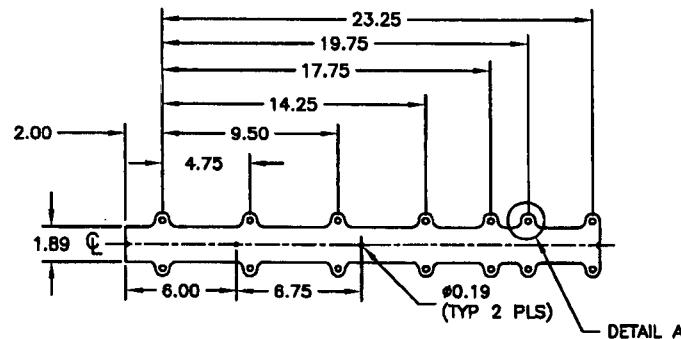
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-33 GASKET

W/0 43368



D3536-35 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	C.B	PRT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
RH	H	D3536
DATE		TITLE
06.10.25		GASKET
REV. A		SCALE
		1:10

**DART**

07.02.07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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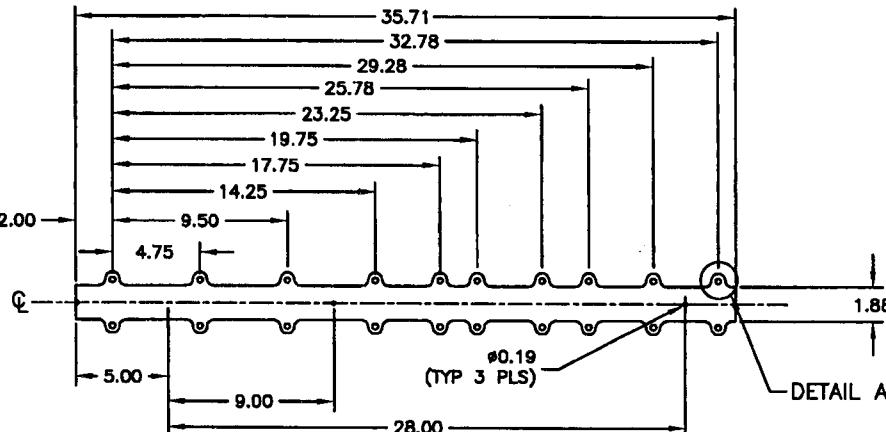
NOTE: Date & initial all entries

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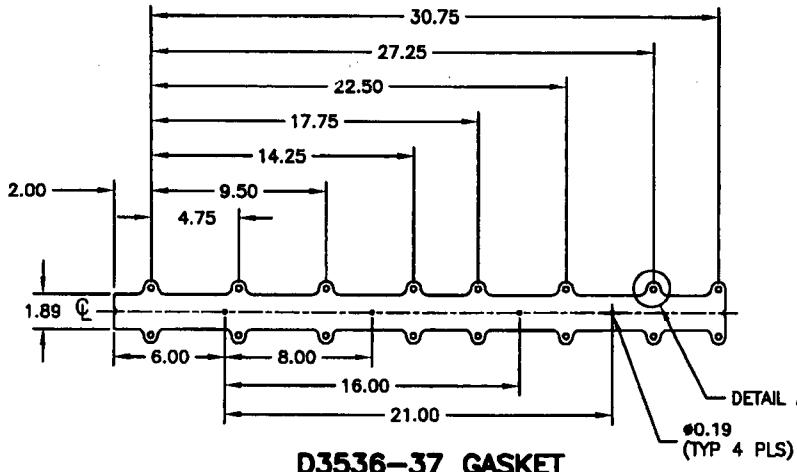
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CHECKED <b>PH</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>		TITLE <b>GASKET</b>
		REV. A SHEET 5 OF 6 SCALE 1:10

07.02.02 off

W/0 43568

**D3536-39 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S-063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-37 GASKET**

W/O:		WORK ORDER CHANGES					
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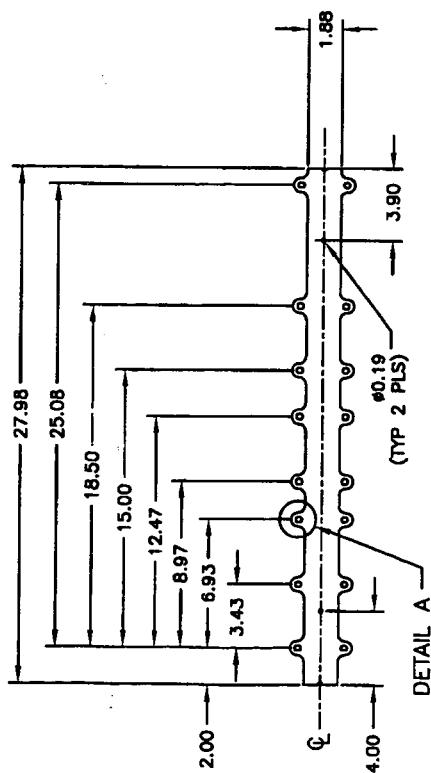
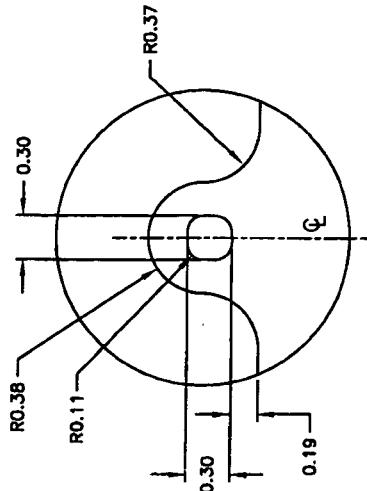
NOTE: Date & initial all entries

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A SHEET 6 OF 6
DATE <b>06.10.25</b>		TITLE <b>GASKET</b>	SCALE 1:10

07.02.12 *[Signature]*

W663548

**DETAIL A****D3536-41 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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